

Date: Tuesday, 7/1/2008 11:36:55 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SPACER		
Job Number	: 40152						
Estimate Number	: 10165						
P.O. Number	:			Part Number	: D25255		
This Issue	: 7/1/2008	S.O. No.	:	Drawing Number	: D2525 REV B		
Prsht Rev.	:	NC		Project Number	: N/A		
First Issue	: 7/1/2008	Type	: MACHINED PARTS	Drawing Revision	: B		
Previous Run	:	34521		Material	:		
Written By	:			Due Date	: 7/22/2008	Qty:	80 Um: Each
Checked & Approved By	:	<i>DK</i> 08.07.01					
Comment	: Est	C	02.08.22	Make in Cobra	KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0750	6061-T6 Round Bar .750"	
		Comment: Qty.: 0.0218 f(s)/Unit Total : 1.7472 f(s) 6061-T6 Round Bar .750 Make as per Dwg D2525 and Folio FA261. Material: 5052-H32 (QQ-A-225/7) or 1100 (QQ-A-225/1) or 6061-T6 (QQ-A-225/8) or 6061-T6 (QQ-A-200/8) Ø0.75 Rod(M5052H32R0.750) or (M6061T6R0.750)	Batch <i>M103857</i> <i>MJ 08/07/05</i>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL 1-Turn Blank as per Dwg D2525 2-Deburr	<i>DEP/MW 08/07/05</i> <i>86</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>DEP/MW 08/07/05</i> <i>86</i>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>MW 08/07/06</i> <i>86</i>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	<i>BR 08-07-07</i> <i>80</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST PPP. 40151

AS 08/07/07 (S)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/07/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40152
Description: Spacer	Part Number:	D2525-5
Inspection Dwg: D2525	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article | Prototype

Measured by:	<i>MHF / DDP</i>	Audited by:	<i>U. A</i>	Prototype Approval:	N/A
Date:	<i>08/07/05</i>	Date:	<i>08/07/05</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.05	New Issue	KJ/JLM	<i>[Signature]</i>

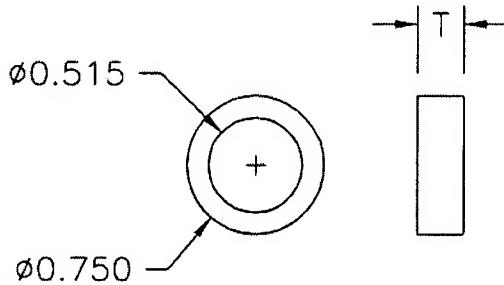
DART

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED H	DRAWING NO. D2525
DATE 99.09.30		REV. B SHEET 1 OF 1
		SCALE 1:1
A	95.12.22	NEW ISSUE
B	99.09.30	REVISED MATERIAL

RELEASED

99.10.12 KE

PART NUMBER	THICKNESS T	QTY
D2525-1	0.750	1
D2525-3	0.250	1
D2525-5	0.125	4
D2525-7	0.063	0
D2525-9	0.032	0



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40152

MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/1)
 OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8)
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1